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D3564-11
Job Sheet 187321



Part No: D3564-11

Job Qty: 12 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/30/18

Job Tracking No:

Due Date: 12/14/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	12/14/18	12/14/18	0.00	2.09	Waterjet - Flow		DE 18/12/02 AS
120	QC	12 pcs	12/14/18	12/14/18	0.00	0.00	QC8		8002 7004 3208 68
130	Brake NC	12 pcs	12/14/18	12/14/18	0.38	0.80	Brake NC 1		30 9-89
140	QC	12 pcs	12/14/18	12/14/18	0.00	0.00	QC5		DEC 17 2018 68
150	Autoweld 1	12 pcs	12/14/18	12/14/18	0.00	5.10	Automated welding		9-89
160	QC	12 pcs	12/14/18	12/14/18	0.00	0.00	QC10		68
170	QC	12 pcs	12/14/18	12/14/18	0.00	0.00	QC5		68
180	SprayPaint	12 pcs	12/14/18	12/14/18	0.00	1.20	Spray Paint		AS 19-1-8 DAS
190	QC	12 pcs	12/14/18	12/14/18	0.00	0.00	QC5		68
200	Packaging	12 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1	FP002	BEB 19-01-09 9-89
210	QC21-SA	12 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DAS

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: E Prog Rev: E 2-Deburr if necessary

Descriptions: 130 - Form on Brake as per Dwg D3564 using Jigs DT8179

150 - 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: M132901

180 - APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG)

5140628

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	16.9200 sf (1.41 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	17	146	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217		
2	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422		
3	Wearshoe	2.500inches $\pm$ 0.010	2.510 2.490		
4	Wearshoe	6.000inches $\pm$ 0.010	6.010 5.990		
5	Wearshoe	12.104inches $\pm$ 0.010	12.114 12.094		
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990		
7	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970		
8	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970		
9	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470		
10	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
12	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
13	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365		
14	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053		

Plex 11/30/18 10:43 AM Dart.Gagnon.Michelle

DART
AEROSPACE

Container No: S133742

Part: D3564 - 11

Job No: 187321

Serial No/Batch: S133742

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/02/18

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